

Work Order ID 70979

Monday, June 20, 2011 2:47:26 PM



Page 1

Item ID:	D3137-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	6/20/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	6/23/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-06-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3137	Rev F								

100
 BAND SAW
 Bandsaw
 Jeaspa Bandsaw
 0.00
 0.00
 Memo
 Cut blanks: (.500" x 2.000") 5.570" long
 11/08/17
 4

110
 HAAS CNC VERTICAL MACHINING #1
 HAAS 1
 HAAS CNC vertical machine #1
 0.00
 0.00
 Memo
 1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7
 2-Deburr 3-Scribe batch number
 B.A 11/08/30
 4

120
 QC2- Inspect parts off machine FAI/FAIB
 QC
 Quality Control
 0.00
 0.00
 Memo
 B.A 11/08/31
 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70979

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Page 2

Item ID: D3137-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 6/20/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/8/31

4

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3137-043 as per Dwg D3137

2511/09/01 (4)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. L. L. L. L.

(4)

W/O:		WORK ORDER CHANGES					
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Page 3

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>5 205B</u>	0.00							
Packaging	Memo	0.00				<u>4K 88</u>	<u>11-09-01</u>		
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/10

MF
11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 2:47:33 PM

Page 1

Work Order ID: 70979

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101  Screw		Purchased	No			100	Each	16.0000	1	4			
<div> <div>Location</div> <div>ST290A</div> <div>110363</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3137-3  Guide		Manufactured	No			140	Each	9.0000	1	4			
<div> <div>Location</div> <div>ST235B</div> <div>67064</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3137-5  Washer		Manufactured	No			140	Each	29.0000	1	4			
<div> <div>Location</div> <div>ST235B</div> <div>68262</div> </div> <div> <div>Loc Qty</div> <div>29</div> <div>29</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

Handwritten signature and date: 6/21/09/01

Handwritten signature and date: 6/21/09/01

Handwritten signature and date: 6/21/09/01

Handwritten number: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 2:47:33 PM

Page 2

Work Order ID: 70979



Parent Item: D3137-043



Parent Item Name: Bracket Assembly

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 4.00

Required Qty: 4.00

M174B0.500X02.000

Purchased

No

140

f

51.7200

0.4643

1.954947



17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT050

51.72

100843

12.9

103089

13

✓ 14932

20.86

19572

4.96

1.9549 F.K. 11/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3137-7
Inspection Dwg: D3137 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.560	+0.006/-0.001	Ø0.562	✓		Vern	GA-01
5.29	+/-0.030	5.288	✓		"	"
2.79	+/-0.030	2.760	✓		"	"
0.67	+/-0.030	0.682	✓		"	"
1.90	+/-0.030	1.890	✓		"	"
					"	
0.262	+/-0.010	0.264	✓		"	"
0.062	+/-0.010	0.062	✓		"	"
4.850	+/-0.010	4.851	✓		"	"
0.162	+/-0.010	0.167	✓		"	"
Ø0.500	+0.006/-0.001	Ø0.501	✓		Vern	GA-01
2.360	+/-0.010	2.361	✓		H-6	31006
1.880	+/-0.010	1.880	✓		H-6	31006
0.480	+/-0.010	0.480	✓		Vern	GA-01

Measured by: B.A	Audited by: SA	Preliminary Approval:	N/A
Date: 11/08/31	Date: 11/8/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev updated	KJ/JLM	
D	08.12.02	Dwg Rev updated	KJ/DD	
E	10.08.03	Dimension 5.29 was 0.529	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

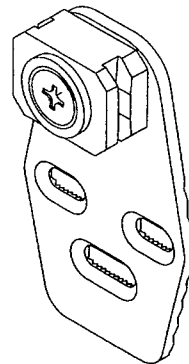
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

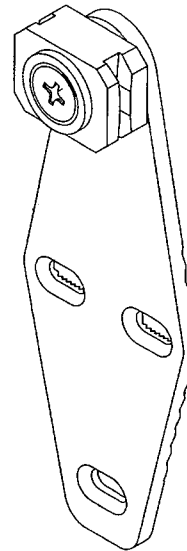
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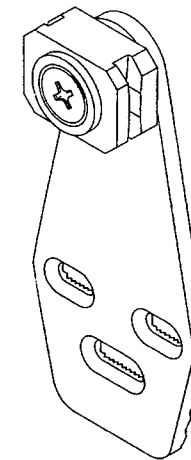
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70979
pl 11-06-20



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

RELEASED
08-06-20

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE A.8 0.67 DIM WAS 0.79, ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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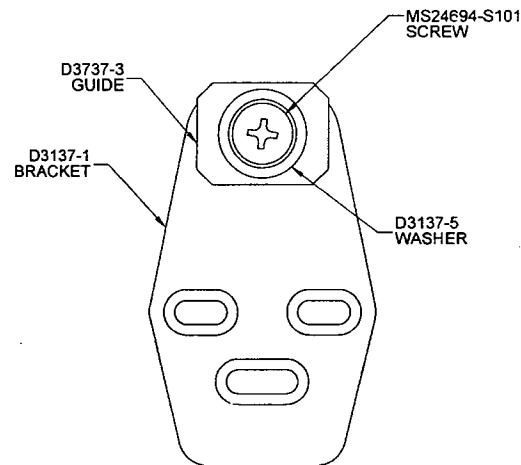
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

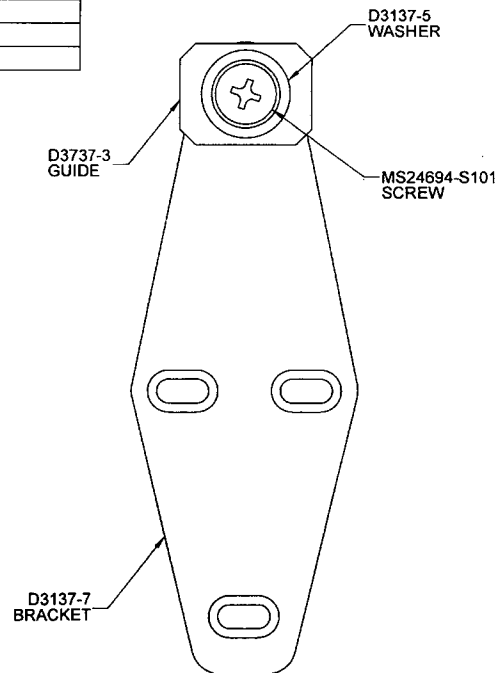
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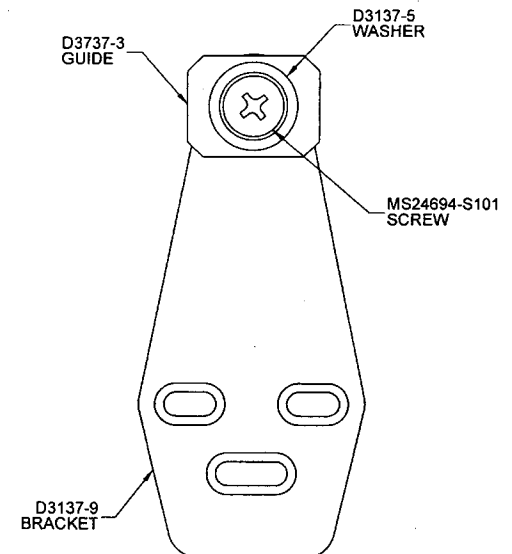
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

RELEASED
08-06-26/11

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

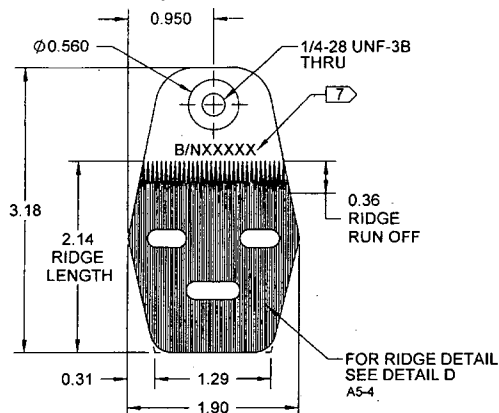
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

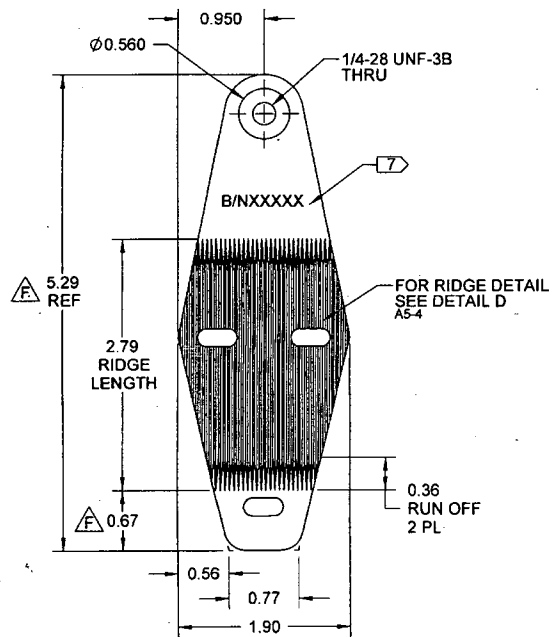
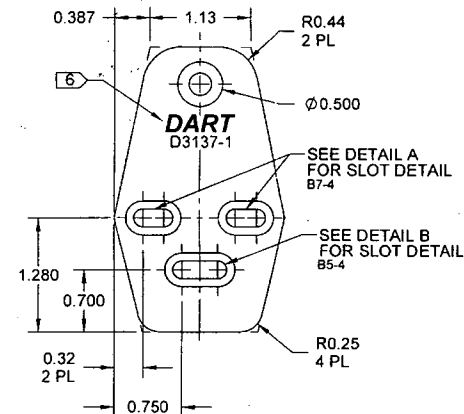
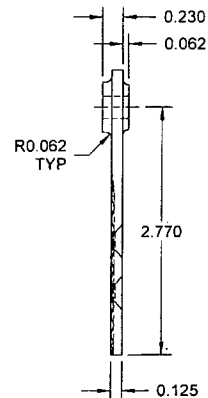
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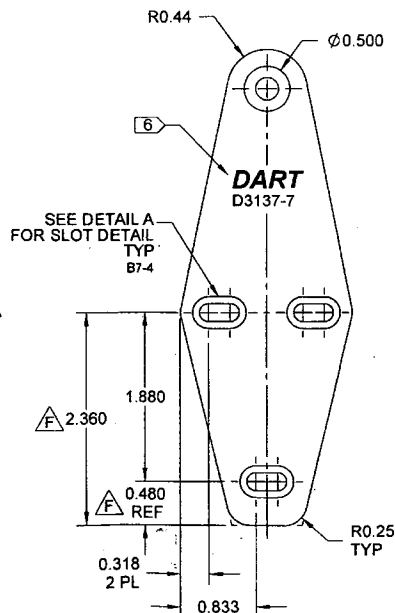
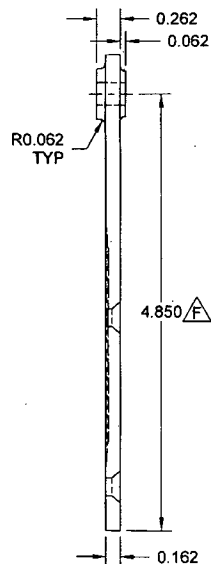
NOTE: Date & initial all entries



D3137-1 BRACKET



D3137-7 BRACKET



- NOTES:**
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
 - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
 - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
 - 9) -1 REPLACES PREMIER P/N B30-23000-105/-1

RELEASED
01-06-26 144

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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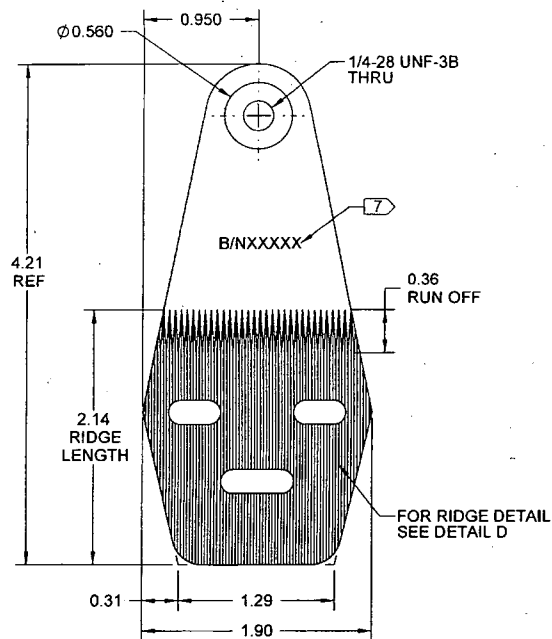
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

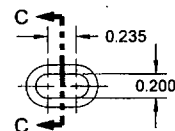
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

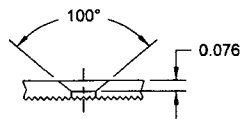
NOTE: Date & initial all entries



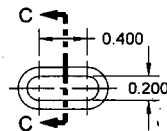
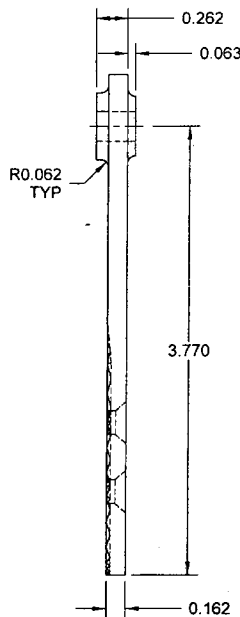
D3137-9 BRACKET



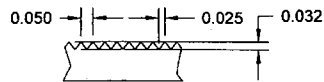
DETAIL A
(SLOT DETAIL)



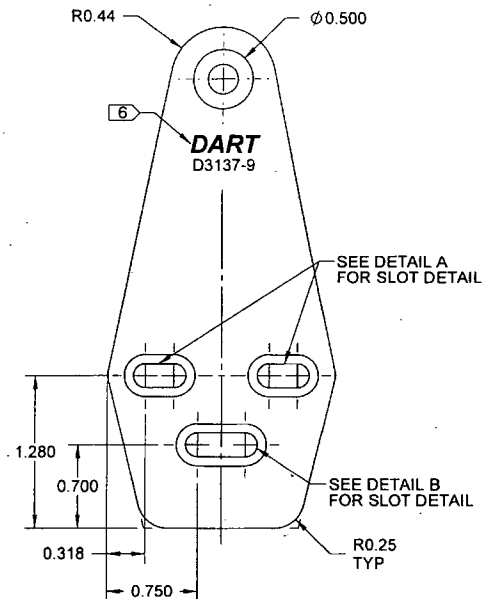
SECTION C-C
(SLOT DETAIL)



DETAIL B
(SLOT DETAIL)



DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)



RELEASED

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/106

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

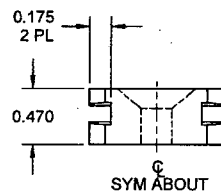
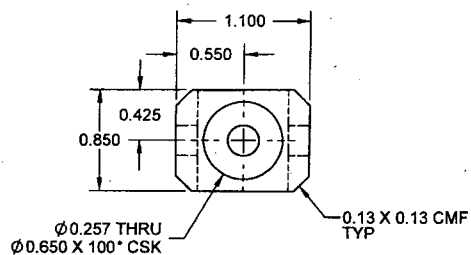
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

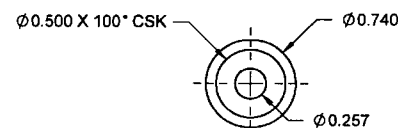
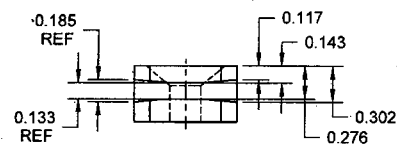
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

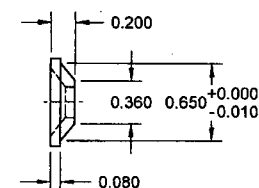
NOTE: Date & initial all entries



D3137-3 GUIDE



D3137-5 WASHER



celo 70979

NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED
080702/14

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	J.AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries